

Work Order ID 161899

Tuesday, May 23, 2017 11:00:55 AM

161899

Page 1

Item ID: D5160-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Shim
 Start Date: 6/8/2017 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 6/23/2017 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: FA **DAS 21 9-89** Date: 20170523 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D5160	A

100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.67							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-Deburr if necessary								

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS 38 9-89
 MAY 29 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : ☐																																																															

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab Small Fab	NC BRAKE Memo C'SINK HOLES AS PER DWG	0.03 1.37				10X			17/05/30 DAS 36 9-89
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				0			DAS 38 9-89 MAY 30 2017
160 *160* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 M 136370 Memo START TIME: 2:40 OVEN TEMPERATURE: 320° FINISH TIME: 3:10	0.00 0.43				10	0	1705-30	23 9-89

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<u>10</u>			<u>38</u> 9-89 MAY 31 2017
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: <u>8358</u> Memo <u>LOCATION: GA</u>	0.00 0.00				<u>10</u>			<u>10</u> MAY 31 2017 DAS 6 9-89
190 *190* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>17/6/2</u> <u>JS</u>

DAS
21
9-89

MAY 31 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Picklist Print

Tuesday, May 23, 2017 11:00:54 AM

Page 1

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161899

Parent Item: D5160-3

D5160-3

Parent Item Name: Shim

Start Date: 6/8/2017

Required Date: 6/23/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 14.10.02 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

100

sf

136.1020

0.017

0.178947

M304S16GA

**

SC 17/05/29

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT010

136.102

m136896

0.3

m137110

0.532

m137175

1.1

m137263

3.17

m137341

5.7

m137400

125.3

0.18

DQA: _____ Date: _____

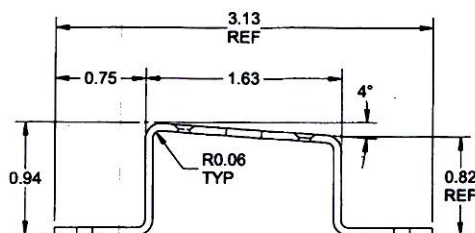
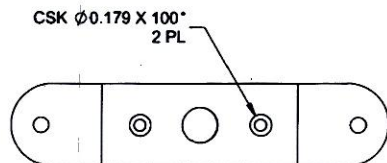


WORK ORDER NON-CONFORMANCE / UPDATE

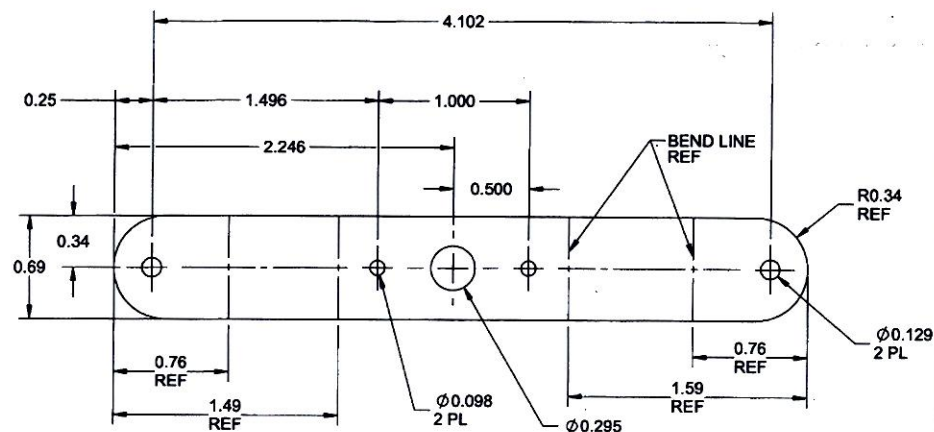
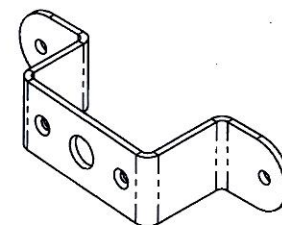
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D5160-1 SEAT BRACE BRACKET
(MAKE FROM D5160-1F)



D5160-1F SEAT BRACE BRACKET
(FLAT PATTERN)

NOTES:

- 1) MATERIAL -1F: AISI 304/316 ANNEALED STAINLESS STEEL SHEET 0.063 THICK
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240
REF DART SPEC. M304S16GA
-1: MAKE FROM -1F
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5160-1" AND B/N BXXXXX
PER DART QSI 044 6.7
- 7) WEIGHT: 0.05 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 161 899
20170523

RELEASED

2015 FEB 04

ECN 15-522 9

APPROVED

A		NEW ISSUE		AJS	14.09.25	
REV.	DESCRIPTION			BY	DATE	
DESIGN	AJS		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	AJS					
CHECKED	AP			DRAWING NO.	REV. A	
MFG. APPR.	DD			D5160	SHEET 1 OF 2	
APPROVED	HS			TITLE	SCALE	
DE APPR.	DS			SHEET METAL PARTS 350 SEAT	NTS	
DATE	14.09.25			COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

